

Date: Wednesday, 11/21/2007 12:50:31 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 35934	
Estimate Number : 10534	
P.O. Number : <i>N/A</i>	Part Number : D2574
This Issue : 11/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 35918	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/23/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: 1 As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574
 Ensure that grain is along 5.00" length
 Batch No: *B31388*

[Signature] 07/12/27

[Signature]

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. *35934* Double check by: *DJP*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

[Signature] 07/12/27

[Signature]

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

[Signature] 07/12/27

[Signature]

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07/12/27

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 08/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:31 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 35934

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/01/04

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AA 100

M. J.

08/01/07

(11X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M/06379

BR 08-01-07

(H)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. J.

08/01/07

(11X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

AS

08/01/07

(X10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/08

(11)

Job Completion



mi 2008/1/8

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 35934
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.751	1.751	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.502	.502	0.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.504	.502	.502	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.571	.568	.567	.567		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.126	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	.250		
S	0.115	0.135		.122	.120	.120	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.233		
V	0.230	0.250		.230	.240	.241	.241		
W	0.115	0.135		.120	.125	.125	0.132		
X	0.307	0.312		.310	.310	.310	0.310		
Y	0.760	0.765		.760	.760	.760	0.760		
Z	0.352	0.372		.370	.370	.370	0.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	0.627		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	.250	.251	.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.F. / Jme
Date: 07/12/20 / 07/12/24

Audited by: SA
Date: 08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	35934
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				51	26	87	48		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.503	0.502	0.502	0.502		
G	0.257	0.262		.258	0.259	0.259	0.259		
H	0.375	0.380		.375	0.376	0.377	0.376		
I	0.490	0.510		.500	0.501	0.502	0.503		
J	1.174	1.184		1.180	1.178	1.177	1.178		
K	0.558	0.578		.568	0.569	0.570	0.569		
L	1.174	1.184		1.180	1.178	1.177	1.178		
M	1.365	1.375		1.370	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	4.119	4.129		4.124	2.122	4.122	4.121		
P	0.115	0.135		.124	0.125	0.125	0.126		
Q	0.115	0.135		.130	0.135	0.135	0.135		
R	0.240	0.260		.251	0.249	0.249	0.249		
S	0.115	0.135		.125	0.126	0.126	0.126		
T	0.178	0.198		.184	0.188	0.188	0.188		
U	3.210	3.250		3.233	3.230	3.230	3.230		
V	0.230	0.250		.240	0.238	0.238	0.239		
W	0.115	0.135		0.130	0.123	0.130	0.131		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.766	0.766	0.766	0.766		
Z	0.352	0.372		0.364	0.364	0.364	0.362		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	0.248	0.247	0.246		
AE	1.500	1.520		1.510	1.514	1.514	1.515		
AF	0.115	0.135		1.125	0.135	0.135	0.135		
AG	0.240	0.280		.260	0.265	0.260	0.265		
AH	0.240	0.260		0.250	0.248	0.248	0.247		
AI	2.000	2.020		2.000	2.005	2.005	2.006		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	RF
Date:	07/12/21 / 02/12/27

Audited by:	SD
Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	35934
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

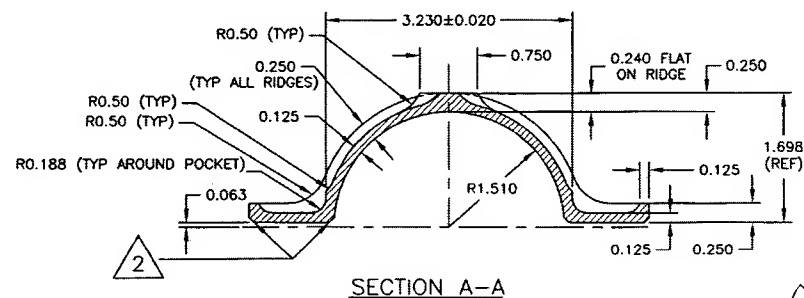
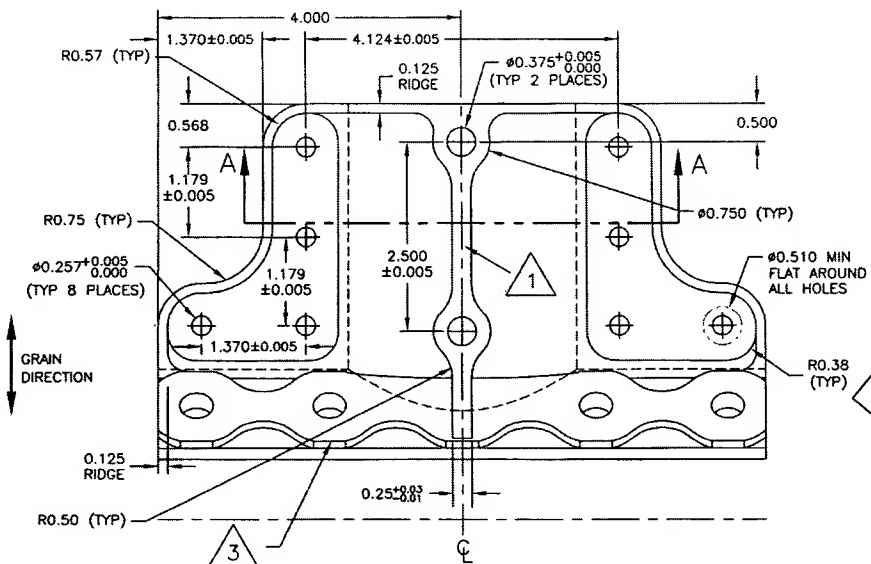
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	211	212	By	Date
A	0.438	0.443		0.446	0.440	0.446	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.505	0.502	0.502	0.502		
G	0.257	0.262		0.259	0.259	0.260	0.259		
H	0.375	0.380		0.377	0.377	0.376	0.376		
I	0.490	0.510		0.503	0.502	0.503	0.502		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.570	0.568	0.570	0.576		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.368	1.369	1.367	1.367		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	4.119	4.129		4.122	4.121	4.121	4.121		
P	0.115	0.135		0.126	0.125	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.248	0.248		
S	0.115	0.135		0.120	0.123	0.121	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.238	0.237	0.237		
W	0.115	0.135		0.130	0.128	0.128	0.128		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.766	0.766	0.766	0.766		
Z	0.352	0.372		0.362	0.363	0.362	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.627	0.627	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.247	0.247		
AE	1.500	1.520		1.514	1.514	1.514	1.515		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.265	0.260	0.260	0.266		
AH	0.240	0.260		0.248	0.249	0.250	0.247		
AI	2.000	2.020		2.005	2.006	2.006	2.006		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	me
Date:	07/12/27

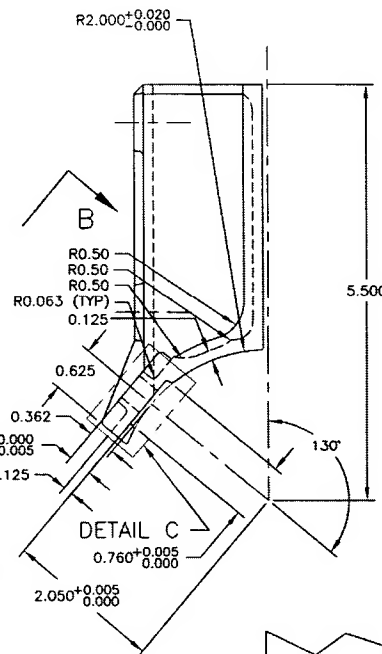
Audited by:	SD
Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06



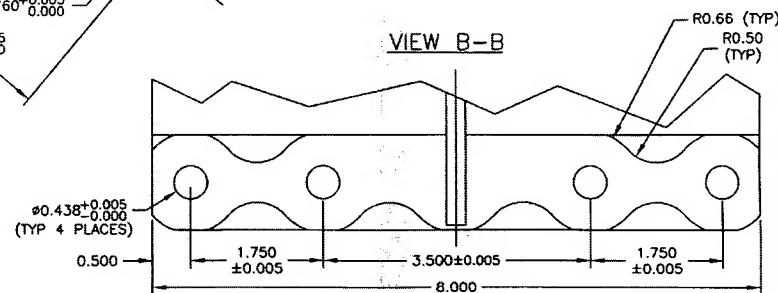
SECTION A-A



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



VIEW B-B

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GROUND DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMMILLERY, ONTARIO, CANADA
DS	PH		
CHECKED	APPROVED	DRAWING NO.	REV.
<i>[Signature]</i>	<i>[Signature]</i>	D2574	SHEET 1 OF
DATE	TITLE		SCALE
05.07.13	INNER AFT SADDLE		2:

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DART AEROSPACE LTD.

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

DRAWING NO.

1 D2574

10.5

Price

INNER

REV. E

SHEET 1 OF 1

2015

SCALE

2:3

DETAIL C
SCALE 2:1

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WORK ORDER
NO. 35934